

Work Order ID 52387

Tuesday, September 22, 2009 11:16:53 AM



Page 1

Item ID: D2565-201

Accept



Setup Start



Revision ID: E

Stop



Item Name: Strut

Start Date: 9/23/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

09-22

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2565

Rev E

100

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Punch as per Dwg D2565 using DT 8313

09/10/08

8

[Signature]

110

0.00



Small Fab

Small Fab

Memo

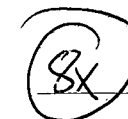
0.00

Small Fab

Drill hole as per Dwg D2565 (one end only)

☐ Deburr

M-h 09/10/09



120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

09/10/09



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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

M112260

0.00

⇒ 41 09/10/13

(XF)

⊗

Powder Coating

START TIME:

11:15am

OVEN TEMPERATURE:

11:45am FINISH TIME:

400°F

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

bk 09-10-13

⊗

Quality Control

150

Identify as per dwg & Stock Location: 270

0.00



Packaging

Memo

0.00

2/24/14 ⊗

Packaging

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Page 3

Item ID: D2565-201

Accept



Setup Start



Revision ID: E

Stop



Item Name: Strut

Start Date: 9/23/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/14 *[Signature]*
09-10-14

Picklist Print

Page 1

Tuesday, September 22, 2009 11:16:53 AM

Work Order ID: 52387



Parent Item: D2565-201RevE



Parent Item Name: Strut

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	286.3500	16.1398			

304 RD Tube .750 x .049W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

286.35

107518

2.77

108498

0

109314

8.5

110113

0.73

110271

0.03

111096

9

111457

11.43

112652

253.89

18

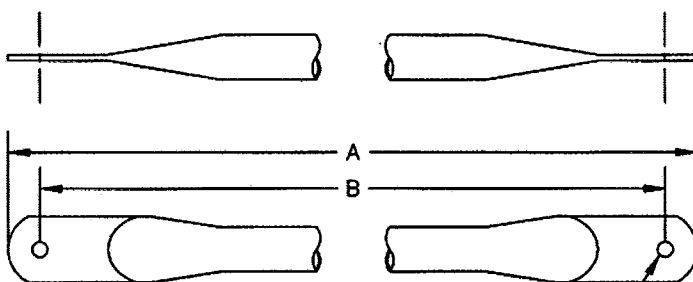
80 09/10/06

8



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT SCALE 1:3	
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED
04.05.05



DIA 0.257 TO BE PUNCHED
"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52387

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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